

Work Order ID 67493

Wednesday, March 23, 2011 6:49:13 AM

PRELIMINARY ISSUE

Page 1

Item ID: D4323-21

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Corner Trim, Outer

Start Date: 3/23/2011 Start Qty: 4.00



Cust Item ID:



Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-03-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4323

PAS

[Signature]

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x4

[Signature]
11/03/29

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°F

Time IN: 4:00 PM 11/03/28

Time OUT: 7:00 am 11/03/29

x4

[Signature]
11/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67493

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Page 2

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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA103 using tool DT9729
Dwg Rev: PA 5
Folio Rev: 1A

x4

Wh
11/03/29

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x4

Wh
11/03/29

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

x4

Wh
11/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67493

Page 3

Wednesday, March 23, 2011 6:49:13 AM

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Setup Start



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Stop



Item Name: Corner Trim, Outer

Start Date: 3/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandThermo	Memo	0.00				x 4			Sh 11/03/29
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150 QC	Memo	0.00				x 4			Sh 11/03/29
Quality Control	Complete FAI document								
160 QC	Memo	0.00							
Quality Control									

QC2- Inspect parts off machine FAI/FAIB

0.00

QC5- Inspect part completeness to step on W/O

0.00

-inspect to PAS

Day only

S. M. G. G.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67493

Wednesday, March 23, 2011 6:49:13 AM



Page 4

Item ID: D4323-21	Accept		Setup Start	
Revision ID: PRELIM			Stop	
Item Name: Corner Trim, Outer				
Start Date: 3/23/2011 Start Qty: 4.00		Cust Item ID:		
Required Date: 3/25/2011 Req'd Qty: 4.00		Customer:		
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo <i>RECALL PO 400</i>	0.00							<i>4/13/11</i>
180 	QC21- Final Inspection - Work Order Release	0.00							<i>11/5/10</i>
QC Quality Control	Memo	0.00							<i>W 11.03.29</i>

POSITIVE RECALL

EFFECTIVE *4/13/11* AUTH *W*

RELEASED *MD* DATE *11/05/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 2:11:09 PM

Page 1

Work Order ID: 67493



Parent Item: D4323-21



Parent Item Name: Corner Trim, Outer

Start Date: 3/23/2011

Required Date: 3/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: Rev. A New Issue 11/03/22 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	825.5300	3.5486 2.666	11.22526			



6185 KYDEX .080"



Location

Loc Qty

Loc Code

therm

825.53

825.53

116576

14.1944

DL
11/03/22 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 62493
Description: Corner trim	Part Number: D4323-21
Inspection Dwg: D4323 Rev: PAS	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than $\frac{1}{2}$ "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

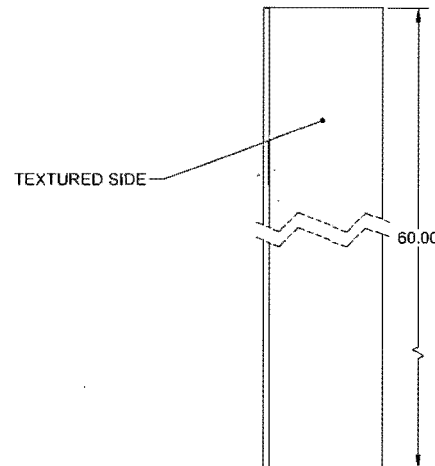
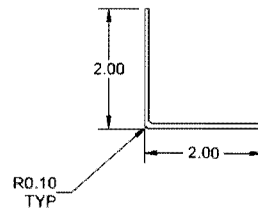
Measured by: LK	Date: 11/03/99
------------------------	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00"	± 0.030	2.00	✓		TAPER 01	
2.00"	± 0.030	2.00	✓		TAPER 01-01	
60.00"	± 0.030	60.125"	✓	✓	TAPER 01-01	11/03/99
0.040"	MIN.	0.060"	✓		UNDER 00926	

Measured by: LK	Date: 11/03/99
Audited by: S. PAS Dm only	Date: 11/03/99
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	



D4323-21 CORNER TRIM, OUTER
D4323-22 CORNER TRIM, INNER (OPPOSITE)

NOTES:

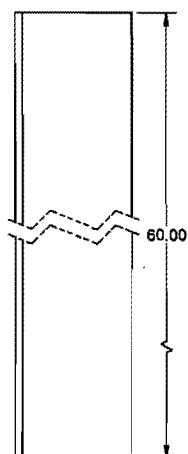
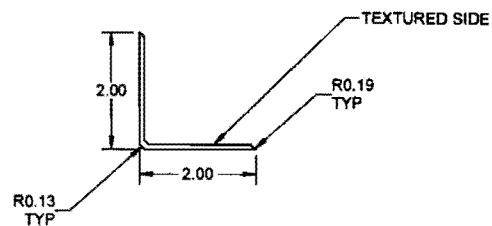
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.68
- 8) TOOLING: THERMOFORM -21 PART PER MOLD DTXXXX. TRIM PER MOLD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 61493
11-03-23

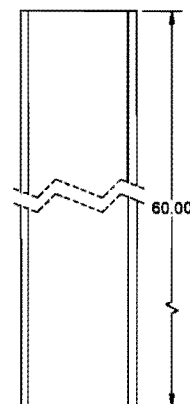
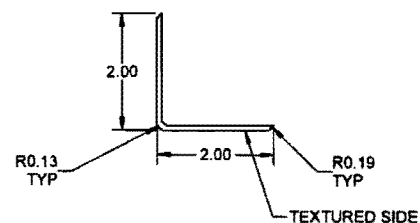
**PRELIMINARY
 ISSUE**

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4323	SHEET 13 OF 13
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

11-10-11
11-10-11
11-10-11



D4323-21 CORNER TRIM, INNER



D4323-22 CORNER TRIM, OUTER

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.51 lb
- 8) TOOLING: THERMOFORM -21/-22 PART PER MOULD DT9729 AND DART QSI 022. TRIM PER MOULD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

RELEASED
2011-05-18
NMS

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO. D4323	REV. A
MFG. APPR.	BC	SHEET 13 OF 15	
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	PANEL	NTS
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